

Work Order ID 80024

Thursday, February 09, 2012 8:11:36 AM

80024

Page 1

Item ID: D4014-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Switch Plate

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-02-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4014

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *S*Prog Rev: *S*

2-Deburr if necessary

B12-2-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*B12-2-10**EP 12/02/13* *(18)*

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

151

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

151

Powdercoat

Memo

0.00

Powder Coating

Start Time:

Oven Temperature:

Finish Time:

W115128

3:30
320°F
4:00

18 BL 12-2 B.

18xØ m / 12/02/15

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

18 0 JH 12/02/29

170

Identify as per dwg & Stock Location: **583**

0.00

170

Packaging

Memo

0.00

Packaging

(18x) SP12-02-29

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/02/29

12-02-29
(18)

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Picklist Print

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Page 1

Work Order ID: 80024
Parent Item: D4014-1
Parent Item Name: Switch Plate

Start Date: 2/10/2012
Start Qty: 16.00
Required Date: 2/24/2012
Required Qty: 16.00

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	221.3860	0.007	0.1178947			

6061-T6 Sheet 0.032"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	221.386	
118106	54.106	
120218	80.6	
120285	86.68	

B12-2-10

(18)

120285

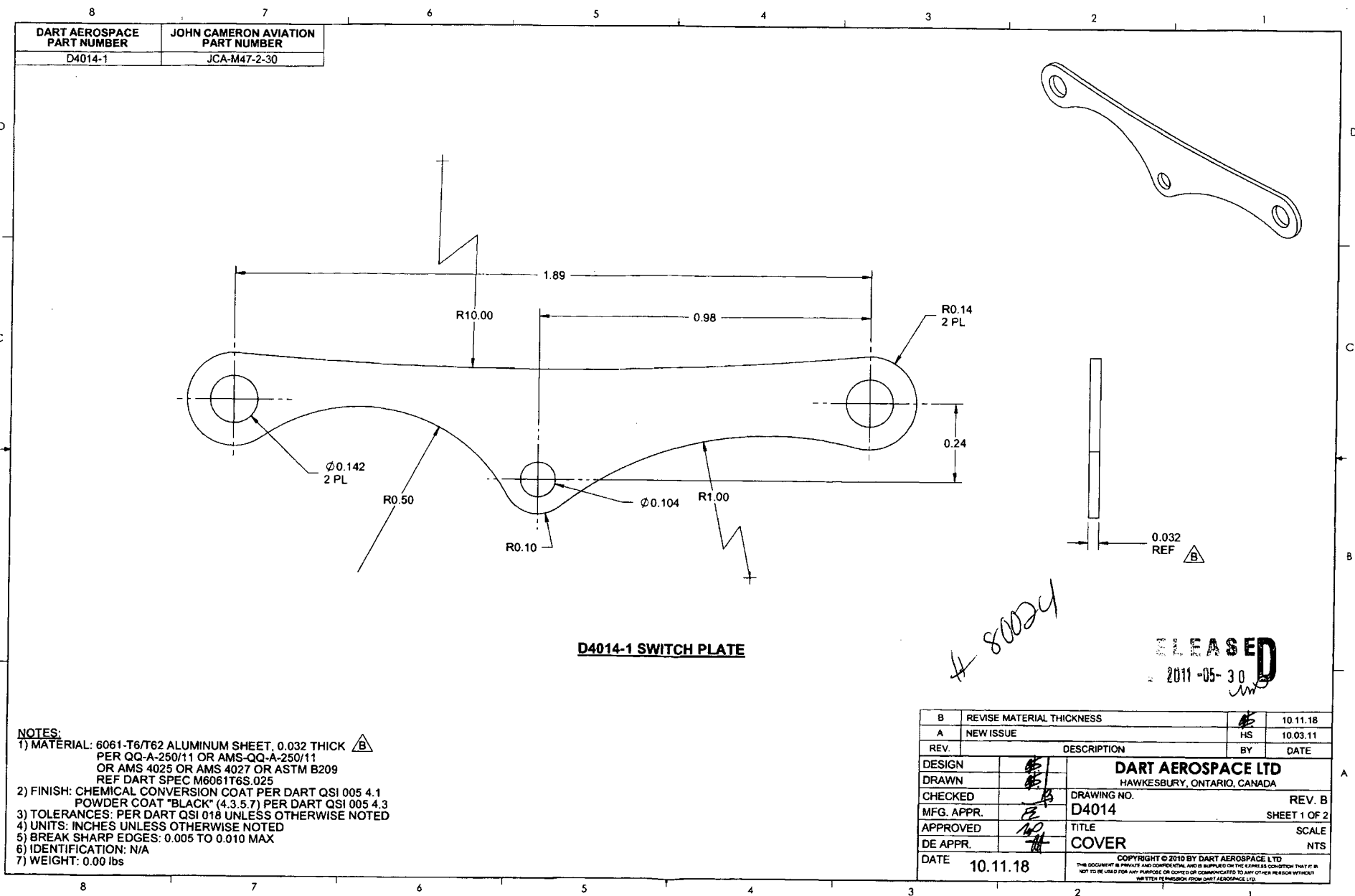
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Dart Aerospace Ltd

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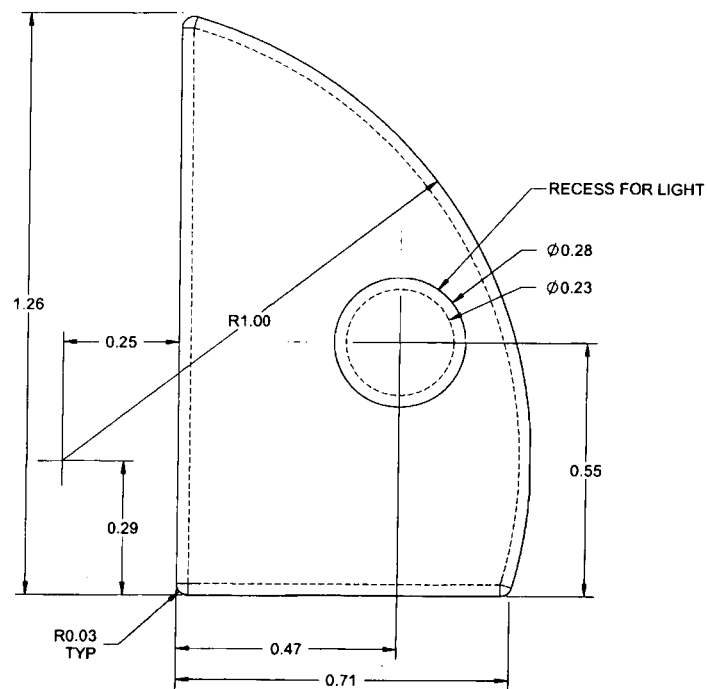
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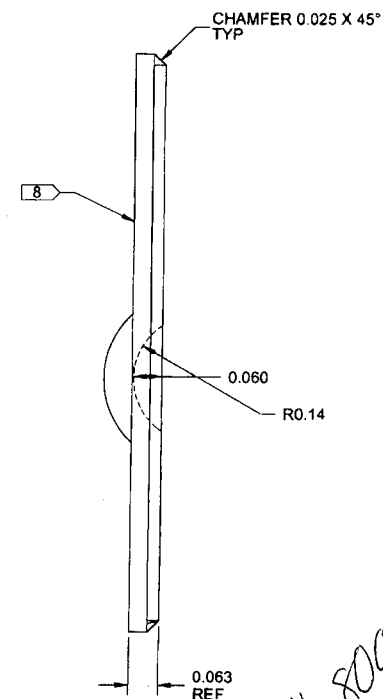
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-3	JCA-M47-2-31



D4014-3 GAUGE COVER



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs
- 8) POWDER COAT THIS SIDE ONLY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4014	REV. B
MFG. APPR.		TITLE COVER	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
DATE	10.11.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2011-05-30

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FIRST ARTICLE INSPECTION CHECKLIST

Measured by: RB	Audited by: S	Preliminary Approval: N/A
Date: 12-2-16	Date: 12/02/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.08.18	New Issue	KJ	

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